












Date: Wednesday, 26/09/2007 1:29:26 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT WELDMENT ASS'Y
Job Number : 34901	
Estimate Number : 10569	
P.O. Number : <u>N/A</u>	Part Number : D34437
This Issue : 26/09/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3443 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 33505	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 03/10/2007 Qty: 8 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : A 05.11.14 New issue EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M304TR0750W120 Inventory
  <p>Comment: Qty.: 0.7875 f(s)/Unit Total: 6.3000 f(s) AISI 304 SS seamless tubing 0.750" OD x 0.120" wall (M304TR0750W120) Batch: <u>1105183</u> FF 07-09-27 8</p>	
2.0	BRAKE NC NC BRAKE
  <p>Comment: NC BRAKE 1- Form as per Dwg D3443 using DT8117 2- Deburr per dwg D3443 FF 07-11-05 8</p>	
3.0	QC5 INSPECT WORK TO CURRENT STEP
  <p>Comment: INSPECT WORK TO CURRENT STEP count 5 7/11/05 (8)</p>	
4.0	MILLING CONV. CONVENTIONAL MILLING MACHINE
  <p>Comment: CONVENTIONAL MILLING MACHINE 1- Mill end to length and drill hole as per dwg D3443 2-Deburr as per dwg D3443 SF 07/11/13 (8)</p>	
5.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
  <p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE SF 07/11/13 (8)</p>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 21/11/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 26/09/2007 1:29:26 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASSY

Job Number: 34901

Part Number: D34437

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Handwritten signature and date: 07-01-14

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

Handwritten checkmark

Handwritten date: 07-11-13

Handwritten number: 8

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten circled '8' and date: 20/11/14

Job Completion



Handwritten date: 07-11-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:2

$\phi 0.210^{+0.005}_{-0.010}$



D3443-9 PIN

D3443-9 NOTES:

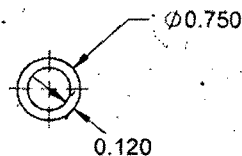
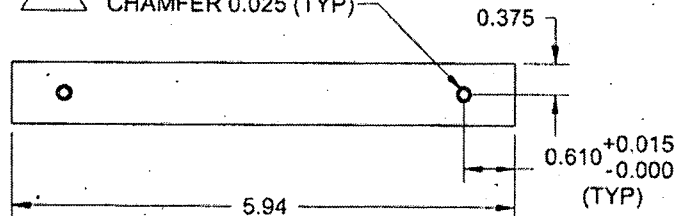
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.12.09

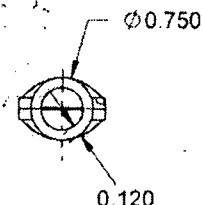


DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)



D3443-5 TUBING

$0.260^{+0.000}_{-0.030}$



R0.51

$\phi 0.438$



DRILL $\phi 0.125$ THRU
CHAMFER 0.025

1.02
(REF)

0.55

1.10 FLATTEN END

8.47

0.375

$0.610^{+0.015}_{-0.000}$

D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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